Work Orde		-	Λ	<u> </u>	974 *-						Page 1
Item ID: Revision ID: Item Name:	D4016-5 Hinge Half, Lig		9 1	Accept	*N900		100)*	Setup Star Stop	IV	S1* S2*
Start Date: Required Date: Reference:		Start Qty: 6.00 \ Req'd Qty: 6.00	*6* *6*		Cust Item II Customer:	D:					
Approvals:	Process Plan	1: Mr2	Date: \2-\2-0\			ite:	·		Run Star Stop	1/1	R1* R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D4016	A										
100		Cut blanks as per folio		0.00							
100 Bandsaw Jeaspa Bandsaw		Memo CUT BLANI	K as per folio	0.00	SL 12-12-10			(2)			
*110				0.00				(1)			DAR 25/0/
HAAS 1 HAAS CNC vertica	I machine #1	Memo MACHINE A FOLIO REV DWG REV:		0.00 ID DWG			·		<u> </u>		. <u>* </u>

DEBURR

Work Order: Part No					DISPOSITION		-11-11-11-11		ACAINST DE	QA Closed:	Date:	·
_				_					A C A INICE DE		_	
Part No						- 1				PARTMENT		
NCR No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
						1				J		JJ
Root				-	ption of work order update	1	nitial	Act		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
						AUL	T CATE	SORY				
Co Cr Cr Cu Hi In	ar ending entre No racks rushed/C uffs eat Treat ispection ipples in orque Wa	crimped. : Strip in i	Tube	/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instructi Mainte Mislabe Misread Offset	on Incomplete ons Incomplete/U nance	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Packaging

Packaging

Page 2

December-04-12 2:57:54 PM Item ID: D4016-5 Accept *N900040100* Setup Start **Revision ID:** Item Name: Hinge Half, Light Lid **Start Date:** 04/12/2012 Start Oty: 6.00 Cust Item ID: **Required Date:** 10/12/2012 **Req'd Oty:** 6.00 Customer: Reference: Run **Process Plan:** Date: Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Otv Run Hours Code Otv Number Stamp 120 QC2- Inspect parts off machine FAI/FAIB 0.00 *120* OC 0.00 Memo **Ouality Control** and 12/12/19 130 OC8- Inspect parts - second check 0.00 *130* 12 1 OC 0.00 Memo **Ouality Control** Identify as per dwg & Stock Location: 160 *160*

0.00

Memo

											DQA	:Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	VFORM	MANCE / UP	DATE			
											QA Closed	: Date:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I						Rework Scrap Use-as-is		f	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet od. Eng. Coor.	Engineering Quality Other
NCR 1	No.					Work Order Update]	t	Large Fab	Composite	1100/310	Supplier	
Root					Descri	ption of work order update		nitial	Ac	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator								٠					
Material													
Setup													
Other											1		
Process													
Supplier													
Training													
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng (Gear				General							
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Unde	r tolerance	Temperature/Cure
	П	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ect	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete	/Unclear	Part Lost/M	lissing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved	i	-
		Heat Trea	at			Countersink		Mislabe	led		Positioned	Wrong	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

December-04-12 2:57:54 PM D4016-5 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Hinge Half, Light Lid **Start Date:** 04/12/2012 **Start Qty:** 6.00 **Cust Item ID: Required Date:** 10/12/2012 Req'd Qty: 6.00 **Customer:** Reference: Run Process Plan: Date: Approvals: **Tooling:** Date: Stop ____ Date:____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 170 QC21- Final Inspection - Work Order Release 0.00 *170* - +0 MF 27 12-12-27 QC 0.00 Memo Quality Control

												DQA:	Date:	!
NCR:	Yes	/ No					WORK ORDER NON-C		NFOR	/ANCE / UPI	DATE	•		
												QA Closed:	Date	
Vork Ord	er:						DISPOSITION		:		AGAINST DE	PARTMENT	/PROCESS	
Part NCR							Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Des	crir	otion of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		-	r Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining														
							F	AUL	T CATE	GORY				
Land		i			,		General		1			7	_	_
		Bending Centre No Cracks Crushed/0		ntric to (O/S		Bend BOM/Route Broken/Damaged Burrs		1 '	re on Incomplete ions Incomplete/U	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Cuffs					Contamination		Mainte	nance		Part Moved		
		Heat Trea	t				Countersink		Mislabe	led		Positioned V	Vrong	_
	L	Inspection	n Strip in	Tube			Cut Too Short		Misread	I		Power Loss/	Surge	Other
		Ripples in	Bend				Drill Holes		Offset					
		Torque W	aves in E	xtrusio	٦		Drawing		Out of (Calibration				
		Turning Se	equence				Finish		Out of S	equence				

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

December-04-12 2:57:58 PM

Work Order ID: 94271

Parent Item:

D4016-5

Parent Item Name: Hinge Half, Light Lid

94271

D4016-5

Start Date: 04/12/2012

Required Date: 10/12/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY:DD

IPP Rev:B

as per dwg REV.A DD 10.02.22 verified by:EC

												- · · · · · · · · · · ·		
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M6061T6B0.750X00.75		Purchased	No	···		100	f	18.0830	0.09	0.568421				

M6061T6B0 750X00 750

**



Location	Loc Qty	Loc Code	
MAT002	8.26		
114993	4.58		
119346	3.68		
MAT003	9.823		
119801	0.081		
121836	6.672		
122321	3.07		(,,,,,)

Page 1

												DQA:	D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UF	PDATE					
												QA Closed:	D	ate:	
Work Ord	or.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Work Ord	-					Rework	1		Skid-tube	Crosstube		1	Water Je	t∏	Engineering
Part I	No.					Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor	\vdash	Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Stor	re/Packaging	g	Other
NCR I	No					Work Order Update]		Large Fab	Composite	L		Supplie	r	
Root			<u> </u>	<u> </u>	Descri	ption of work order update	Τ.	Initial	Λ.	ction		Sign &			
Cause		Date	Step	Qty	l	or Non-conformance	1	nief Eng		cription		Date	Verificati	on	QC Inspector
Doc/Data	П	Dute	эсер	Qty	`	or non comormance	-	iici ciig	DC3	cription	—	Date	Vermeati	0	QC IIISPECTOI
Equip/Tooling	H														
Operator	П													ļ	
Material	П													ŀ	
Setup	П														•
Other	П		ļ												
Process	П													ļ	
Supplier														ľ	
Training															
Unapproved							<u> </u>								
						F	AUL	LT CATE	GORY						
Landi	ing G	ear				General		,				-		_	,
	Ш	Bending				Bend		Grain				Ovalized		_	Pressure/Forced
	\vdash	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa			L	Over/Under		_	Temperature/Cure
	-	Cracks				Broken/Damaged		- 1 '	ion Incomplete			Part Incorre			Weld
	-	Crushed/	Crimped.		<u>_</u>	Burrs	_	1	ions Incomplete	/Unclear	\vdash	Part Lost/Mi	issing	L	Wrong Stock Pulled
1		Cuffs				Contamination		Mainte	enance			Part Moved			

Mislabeled

Out of Calibration
Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	94271
Description: Hinge Half, Light Lid	Part Number:	D4016-5
Inspection Dwg: D4016 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	875			wrn 1-10	
0.13	+/-0.030	-125				
0.250	+/-0.010	-250				
R0.03	+/-0.030	,030				
0.13	+/-0.030	-125	/			
0.50	+/-0.030	502				
0.63	+/-0.030	624				
0.563	+/-0.010	563	//			
Ø0.257	+0.006/-0.001	,257				
					}	
•						
						•

Measured by:		Audited by:	of	Preliminary Approval:	
Date:	12-12-19	Date:	12/12/19	Date:	

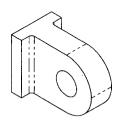
Rev	Date	Change	Revised by	Approved
Α	10.06.07	New Issue	KJ 95	

D

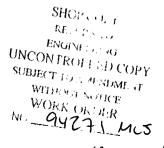
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В

D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



12-12-DY

D4016-5 HINGE HALF, LIGHT LID

RELEASED 2010 -02- 16

Α	NEW IS	SUE		JPH	10.01.29
REV.			DESCRIPTION	BY	DATE
DESIG	V	AJS	DART AERO	SPACEL	D
DRAW	Z	AJS	HAWKESBURY, C		_
CHECK	ŒD	a	DRAWING NO.		REV. A
MFG. A	PPR.	77	□ D4016		SHEET 1 OF 2
APPRO	VED	140.	TITLE		SCALE
DE AP	PR.	_#	BASKET HINGE		NTS
DATE	10.0	1.29	COPYRIGHT © 2010 BY THE DOCUMENT IS FRANKTE AND COMPONITUL AND NOT TO BE USED FOR ANY PURPOSE OF COPIED ON ANY PURPOSE OF COPIED ON ANY PURPOSE OF COPIED OF THE PURPOSE OF THE PURPO	IS SUPPLIED ON THE EXPRES	CONDITION THAT IT IS

D D GRAIN DIRECTION - 0.88 0.13 0.250 0.50 0.875 0.25 R0.03 0.38+0.03 -- 0.13 R0.38 C Ø 0.257 THRU REF R0.31 **-** 0.563 -REF GRAIN DIRECTION 0.88 0.63 0.50 0.13 Ø0.257 THRU R0.03 TYP - 0.75 **D4016-3 HINGE HALF, LID D4016-1 HINGE HALF, BASE D4016-5 HINGE HALF, LIGHT LID** NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B -5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 DESIGN AJS DART AEROSPACE LTD Α REF DART SPEC M6061T6B REF DART SPEC M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs DRAWN AJS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4016 MFG. APPR. SHEET 2 OF 2 APPROVED TITLE BASKET HINGE

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THO DOCUMENT IS THANK THE CONTROL HIS SHAMES OF THE DARTS AEROSPACE LTD

WIT TO AR VISIT ON A VISIT OF THE PROPERTY OF T SCALE DE APPR. NTS -3: 0.04 lbs -5: 0.01 lbs DATE 10.01.29